



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-3
Job Sheet 177472



Part No: D4681-3

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Due Date: 5/31/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV B SHEETS 3,4 IPP REV:A 13.09.23 NEW ISSUE DD VERF:JFS IPP REV:B 13.11.14 AS PER
DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		5/31/18	0.00	0.00	Start Up Waterjet		SC 18/06/18
100	Waterjet	20 pcs		5/31/18	0.00	4.14	Waterjet1		SC 18/06/18
110	QC	20 pcs		5/31/18	0.00	0.00	QC2 Waterjet-3		SC 18/06/18
120	QC	20 pcs		5/31/18	0.00	0.00	QC8-5		38
130	Brake NC	20 pcs		5/31/18	0.00	1.32	Brake NC 1		DAS 38
140	QC	20 pcs		5/31/18	0.00	0.00	QC5		38
150	HandFinish	20 pcs		5/31/18	0.00	1.65	HandFinish1		SA 18-07-04
160	QC	20 pcs		5/31/18	0.00	0.00	QC7-4		38
170	Packaging	20 pcs		5/31/18	0.00	0.00	Packaging3-2		38
180	QC21-SA	20 Ea		5/31/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: BV 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Form as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - Chemical Conversion Coat per QSI005 4.1
 160 - QC7-Inspect Chemical Conversion Coat
 170 - Identify as per dwg & Stock Location: _____ LOCATION : LG001
 180 - QC21- Final Inspection - Work Order Release

JUL 13 2018

DAS
53
9-89

Job BOM

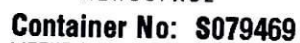
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	1.6000 sf (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	2	178	0

Part Specifications

Specifications could not be found.



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Part: D4681-3

Job No: 177472

Serial No/Batch: S079469

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/09/18

72
22
74

